

Work Order ID 65344

Page 1

January 12, 2011 11:45:51 AM

Item ID: D3272-1

Revision ID:

Item Name: Step

Start Date: 1/12/11

Start Qty: 1.00

Required Date: 1/26/11

Req'd Qty: 2.00

Accept



Setup Start



Stop



Reference:

Approvals: Process Plan: CL

Date: 1/10/11 Tooling: _____ Date: _____

QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3272	Rev B

100



Large Fab

Large Fab

Memo

0.00

0.00

11.01.18

3

P

Large Fab

SQUARE ONE END BEFORE CUTTING OTHER END

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

110



QC6- Inspect dimensions to drawing

0.00

11.01.18

QC

Memo

0.00

Quality Control

(A)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65344

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January 12, 2011 11:45:51 AM

Item ID: D3272-1

Accept



Setup

Start



Revision ID:

Item Name: Step

Stop



Start Date: 1/12/11 Start Qty: 2.00



Cust Item ID:

Required Date: 1/26/11 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

120



Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: WAFSet Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

PL 11-01-18

*3**f*

11/01/19

*JF**11-01-19*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <u>WAF</u>	0.00	<i>PL 11-01-18</i>			<i>3</i>	<i>f</i>		
Packaging	Memo	0.00							
Packaging	Memo	0.00							
130	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control	Memo	0.00							

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NOTE: Date & initial all entries

Picklist Print

January 12, 2011 11:45:50 AM

Page 1

Work Order ID: 65344



Parent Item: D3272-1



Parent Item Name: Step

Start Date: 1/12/11

Required Date: 1/26/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	9.7000	1	2		PL 11.01.18	

Step Extrusion

Location	Loc Qty	Loc Code
WA 364409	9.7	3
55214	3.42	
58544	1	
61208	5.28	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>QP</i>	DRAWN BY <i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>TH</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01 NEW ISSUE		
B	07.05.18 D3272-1 WAS D2622-120		

RELEASED07.06.04 *TH*

B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT

WITHOUT NOTICE
 WORK ORDER
 NO. 6534

CZ 11/01/12

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W/O:		WORK ORDER CHANGES					
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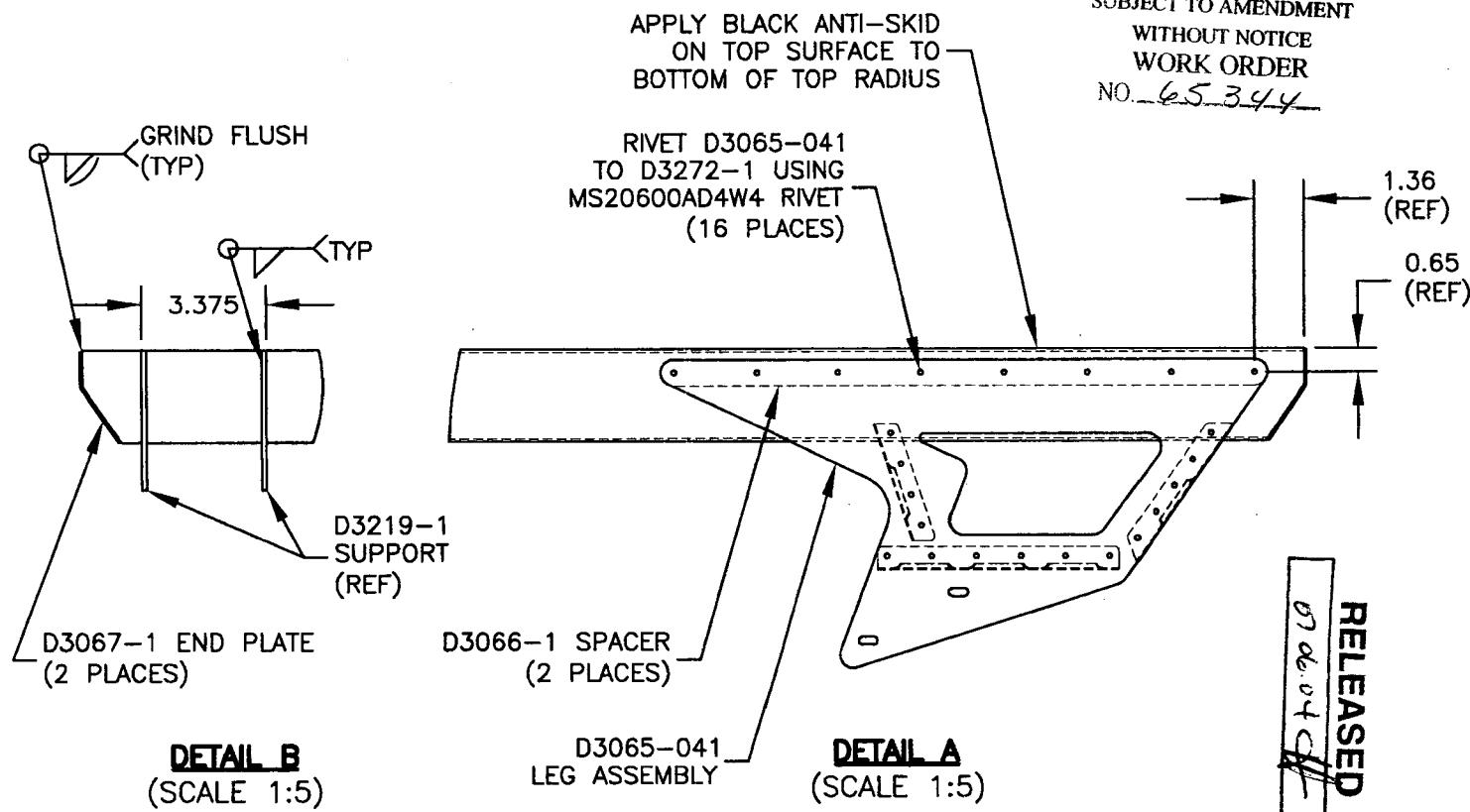
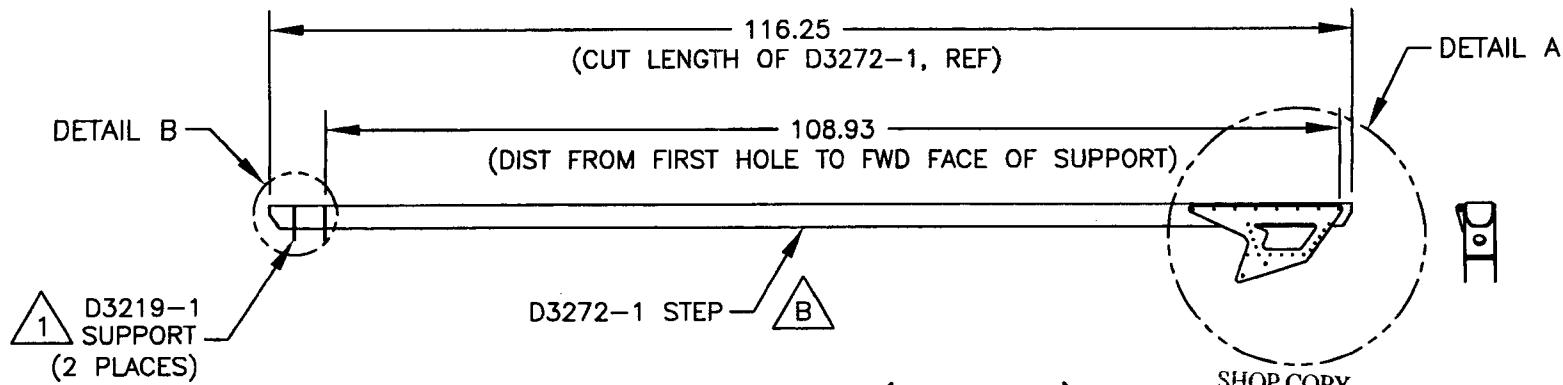
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>4P</i>	DRAWN BY <i>JF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>LE</i>	APPROVED <i>MF</i>	DRAWING NO. D3272
DATE 07.05.18	TITLE STEP ASSEMBLY, LH LONG	REV. B SHEET 2 OF 3 SCALE 1:20



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

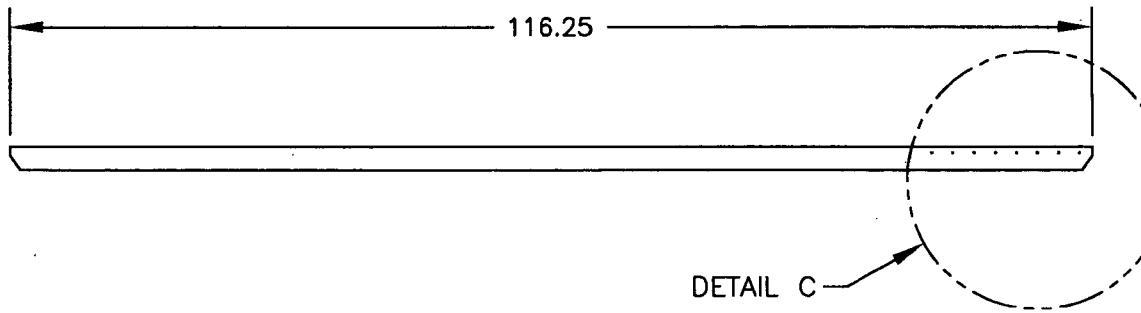
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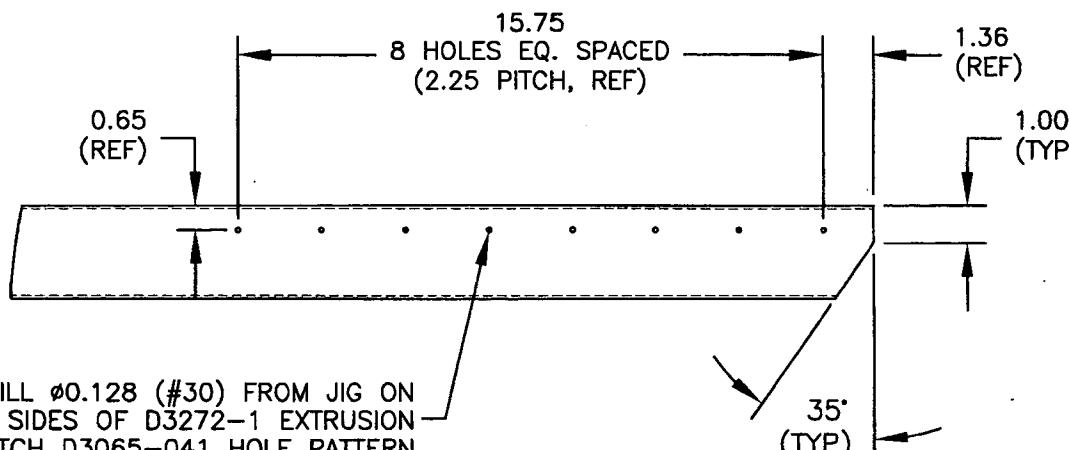
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B **D3272-1 STEP**

(MAKE FROM D2622-120 STEP EXTRUSION)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 65344



DETAIL C
(SCALE 1:5)

RELEASED
07.06.04

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
<i>CE</i>	<i>H</i>	DRAWING NO. D3272
DATE		TITLE STEP ASSEMBLY, HI LONG
07.05.18		REV. B SHEET 3 OF 3 SCALE 1:20

*Step
Detail
C*

DART

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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